

**Work Order ID 58791**

Wednesday, May 19, 2010 9:17:03 AM



Page 1

Item ID: D350-600-242

Accept



Setup Start



Revision ID:

Item Name: Spacepod, RH, AS350/355

Stop



Start Date: 5/18/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/25/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: PHDate: 10-5-09

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

IIN D350-600

Rev C

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-600-242 CHG001

8/10/09

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Drill holes in D3188-2 using drill jig DT8971  
2-Open holes in D3188-2 body floor to Ø0.297" as per dwg D3188  
3-Deburr  
4-Install inserts in D3188-2 as per Dwg D3188.

8/11-03-03

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

8/10/078  
(70)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Required Date: 5/25/2010 Req'd Qty: 1.00



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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

0.00



Small Fab

Small Fab

Memo

0.00

1-Cut D2986 Neoprene Foam per template D2986T1

2- Adhere D2986 foam to bottom side of D3187-2 spacepod floor using contact adhesive

A/R Batch: \_\_\_\_\_

*N/A as foam already installed as per B#59241**U*

140

0.00



Small Fab

Small Fab

Memo

0.00

\*\*\*\*This step separates hardware, previous steps is for body &amp; floor\*\*\*\*

W/O:		WORK ORDER CHANGES					
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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble D3186-4 door with D3188-2 body as per Dwg ICA-D350-600  
\*\*\*Hardware on previous steps is for door ass'y\*\*\*\*

1-Drill and plug section I-I and J-J of dwg D3188 p.11 using Hysol 934NA with  
milled fibres 10% to weight. Install insert.

A/R Hysol batch: 115222 expire date: 11-07-16 BT 11-03-03

A/R Milled fibres batch: \_\_\_\_\_

2- Prime (grey) as necessary per QSI005

Primer batch: 116563Hardner batch: 116563

BT 11-03-05

3-Attach Neoprene Foam to floor using Contact Cement

A/R Contact Cement Batch: \_\_\_\_\_

N/A Foam already installed W  
as per B# 59241

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 11/03/07

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Run Start

Stop

Sequence ID/  
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Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

Wing Walk as per dwg QSI005 4.4 Batch 116402 0.00

HandFinish

Memo

0.00

Hand Finishing

Wing Walk Spacepod top surface of Pod as per Dwg D3188

85 CC-03-07

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 φ 11/03/07

200

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/3/07

W/O:		WORK ORDER CHANGES					
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


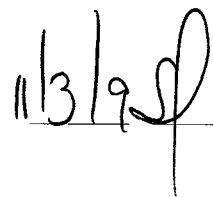

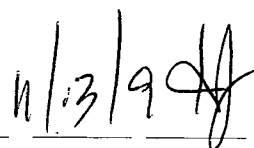
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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210  QC Quality Control	QC4- 100% Inspect kits for completeness  Memo	0.00 0.00							
220  Packaging Packaging	Packaging  Memo Identify and pack for shipping as per PPP D350-600-242 Location: _____ PPP Rev:  _____	0.00 0.00							
230  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							

C211103109

W/O:		WORK ORDER CHANGES					
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IPP rev B 07.04.16 reformat, D3188 rev.E EC  
IPP Rev:C 08-09-30 add primer in step 44 DD verified by:EC IPP Rev:D  
add install insert seq150 DD 10.03.15 verified by:EC IPP Rev:E remove

Start Qty: 1.00

Required Qty: 1.00

D3188-6 Manufactured No 110 Each 0.0000 1  
Spacepod Body  
D3015-3 Manufactured No 130 Each 187.0000 1  
Locknut

B58919

64275

BT 11-03-02

BT 11-03-03

## Location

## Loc Qty

## Loc Code

ST033

187

43758

26

56701

3

58202

158

AN526C832R24 Purchased No 140 Each 64.0000 4  
screw

115518

BT 11-03-03

## Location

## Loc Qty

## Loc Code

ST327

64

110179

64

AN960JD516 Purchased No 140 Each 0.0000 1

116540

BT 11-03-03

Washer  
AN960JD8 Purchased No 140 Each 0.0000 4

116857

BT 11-03-03

Washer  
D2179 Manufactured No 140 Each 53.0000 2  
Doubler

BT 11-03-03

## Location

## Loc Qty

## Loc Code

ST007

53

35432

53

XZ

W/O:		WORK ORDER CHANGES					
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Start Qty: 1.00

Required Qty: 1.00

D2237 Manufactured No 140 Each 99.0000 2



Striker Plate

64762



ET 11-03-03

Location Loc Qty Loc Code

ST009 99  
57255 40  
58181 59

D2986 Manufactured No 140 Each 0.0000 5.62



Black Neoprene Foam .125

NA already applied to floor as per B# 59241 N<sup>sf</sup>



D3538-1 Manufactured No 140 Each 22.0000 2



Hinge Bracket



ET 11-03-03

Location Loc Qty Loc Code

ST069 22  
55012 10  
56531 12

D3554-7 Manufactured No 140 Each 36.0000 1



Ball Stud



ET 11-03-03

Location Loc Qty Loc Code

ST070 36  
37674 36

x1

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Start Qty: 1.00

Required Qty: 1.00

D3567-2 Manufactured No 140 Each 25.0000 1



Decal



ET 11-03-03

Location Loc Qty Loc Code

ST070 25

39678 6

50375 19

x 1

MS20426AD4-5 Purchased No 140 Each 6,056.000 4



Rivet



ET 11-03-03

Location Loc Qty Loc Code

ST317 6056

6733 1074

6874 4982

x 4

ALS4-1032-130 Purchased No 150 Each 2,223.000 28



Insert



ET 11-03-07

Location Loc Qty Loc Code

ST282 446

110511 38

114407 408

ST381 1777

114654 1777

M 116864

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Start Date: 5/18/2010

Required Date: 5/25/2010

Start Qty: 1.00

Required Qty: 1.00

AN526C832R10 Purchased No 150 Each 195.0000



Screw

Location Loc Qty Loc Code

ST327 195  
104603 3  
113154 100  
113288 42  
114382 50

x10

ST 11-03-03

AN526C832R14 Purchased No 150 Each 746.0000



Screw

Location Loc Qty Loc Code

ST327 746  
104916 746

x10

ST 11-03-03

AN960JD10 Purchased No 150 Each 0.0000



Washer

NAS1149003635

116583

x2

ST 11-03-03

AN960JD8 Purchased No 150 Each 0.0000



Washer

116857

x16

ST 11-03-03

D2228 Manufactured No 150 Each 46.0000



Bracket Plate

64427

ST 11-03-03

Location Loc Qty Loc Code

ST009 46  
48228 46

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Start Date: 5/18/2010

Required Date: 5/25/2010

Start Qty: 1.00

Required Qty: 1.00

D2464 Manufactured No 150 f 369.1934 10.8



3/4 Seal

61878



ET 11-03-07

Location Loc Qty Loc Code

ST402 369.1934

48173 369.1934

D2585 Manufactured No 150 Each 52.0000 2



Mounting Channel

64761



ET 11-03-03

Location Loc Qty Loc Code

ST018 14

55313 14

ST019 38

56524 38

D2586 Manufactured No 150 Each 129.0000 2



Door Latch

64656



ET 11-03-03

Location Loc Qty Loc Code

ST006 100

57917 100

ST204 29

55314 29

D2621 Manufactured No 150 Each 93.0000 2



Latch Plate, 350 Spacepod

Location Loc Qty Loc Code

ST021 93

46842 24

56526 69

Y 2

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Start Date: 5/18/2010

Required Date: 5/25/2010

Start Qty: 1.00

Required Qty: 1.00

D2857-1 Manufactured No 150 Each 23.0000 1



Hinge Bracket

64435



25 11-03-03

Location Loc Qty Loc Code

ST026 23

55019 4

56529 19

D2857-2 Manufactured No 150 Each 33.0000 1



Hinge Bracket

64463



25 11-03-03

Location Loc Qty Loc Code

ST027 33

55020 13

56530 20

D3557-1 Manufactured No 150 Each 15.0000 1



Bracket

64452



25 11-03-03

Location Loc Qty Loc Code

ST070 15

50283 15

MS21042L08 Purchased No 150 Each 383.0000 18



Nut

116823



25 11-03-03

Location Loc Qty Loc Code

ST300 383

114330 383

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Start Date: 5/18/2010

Required Date: 5/25/2010

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased No

150 Each

1,918.000 2



115835 ✓



25 11-03-03

Nut

Location	Loc Qty	Loc Code
ST300	1918	
113537	20	
113644	398	
114523	1000	
114718	500	

MS27039-08-11

Purchased No

150 Each

89.0000 2



116289



25 11-03-03

Screw

Location	Loc Qty	Loc Code
ST288	50	
114382	50	
ST290	39	
113749	39	

MS27039-1-15

Purchased No

150 Each

171.0000 2



116169



25 11-03-03

Screw

Location	Loc Qty	Loc Code
ST292	171	
114056	71	
114718	100	

Wednesday, May 19, 2010 9:17:09 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



# Picklist Print

Wednesday, May 19, 2010 9:17:09 AM

Page 8

Work Order ID: 58791

Parent Item: D350-600-242

Parent Item Name: Spacepod, RH, AS350/355

Comments: IPP Rev:A 07.03.07 new issue EC  
 IPP rev B 07.04.16 reformat, D3188 rev.E EC  
 IPP Rev:C 08-09-30 add primer in step 44 DD verified by:EC IPP Rev:D  
 add install insert seq150 DD 10.03.15 verified by:EC IPP Rev:E remove

Start Date: 5/18/2010

Required Date: 5/25/2010

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3

Purchased No

150 Each

142.0000 2



Washer

115935



11-03-02

Location

Loc Qty

Loc Code

ST277

142

111268

142

D350-600-449

24167001

Manufactured No

200 Each

0.0000 1



Switch Relocation

K10021

Manufactured No

200 Each

0.0000 1



Spacepod Hardware Kit (-241)

D3186-4

Manufactured No

110 Each

0.0000 1



Spacepod Door, RH

D3187-2

Manufactured No

110 Each

0.0000 1



Spacepod Floor

A3235-020-935

Purchased No

110 Each

556.0000 8



Washer - Countersunk

Location

Loc Qty

Loc Code

ST281

556

106150

556

11-03-03

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Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**GENERAL NOTES:**

1) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)  
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")  
18 oz ROVING "E" GLASS (18 oz CLOTH)  
OWENS CORNING MILLED FIBERS, "E" GLASS  
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL  
OR DIVINYCELL  
OR AIREX  
OR KLEGECELL  
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

1. MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

2) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S.  
APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: D3188-1 = N/A  
D3188-2 = N/A  
D3188-3 = N/A  
D3188-5 = N/A  
D3188-6 = N/A  
D3188-7 = N/A

8) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING

9) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER

NO. 58791

BS10-5-19

RELEASED  
2009-10-20  
MP

F	REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENTS STANDARDS; ADD CHAMFER IN SECTIONS A-A (ZN C7-10) & H-H (ZN B7-11)	RF	09.07.13
E	ADD HYSOL/ FIBER OPTION ON SHEET 11	CB	07.04.02
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	CB	06.10.06
A	NEW ISSUE	CP	03.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 1 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
DATE	09.07.13	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

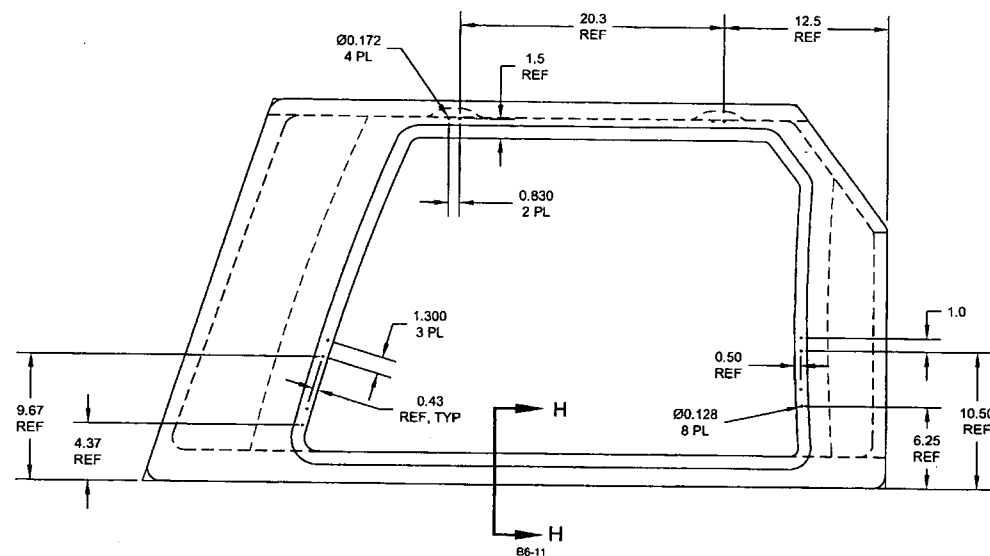
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			





**NOTE:** Date & initial all entries



**D3188-1 SPACEPOD BODY**  
MAKE FROM D3188-1M

**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

DESIGN	JB	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3188	SHEET 2 OF 11
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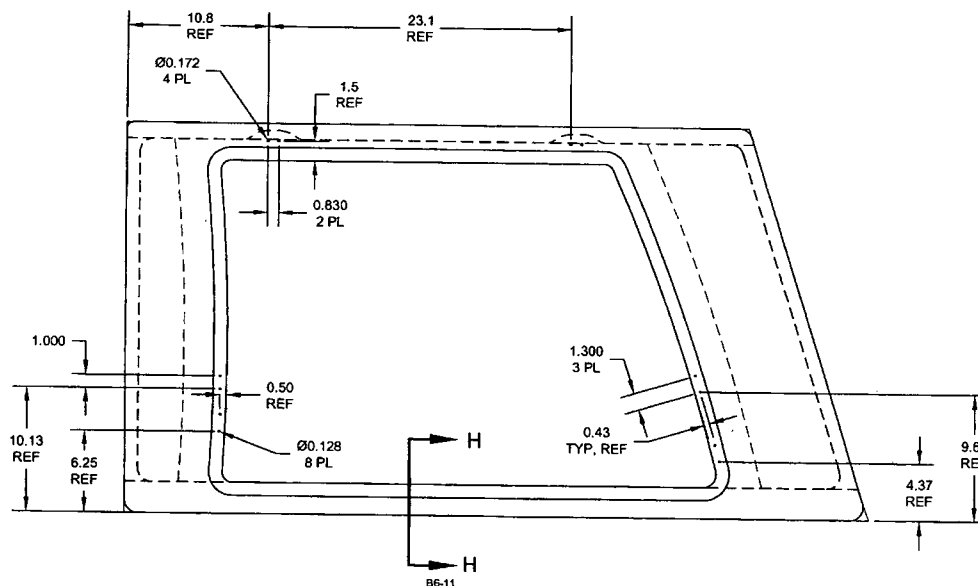
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3188-2 SPACEPOD BODY**  
MAKE FROM D3188-2M

**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

DESIGN	JB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<del>RF</del>	DRAWING NO.	REV. F
MFG. APPR.	<del>RF</del>	D3188	SHEET 3 OF 11
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

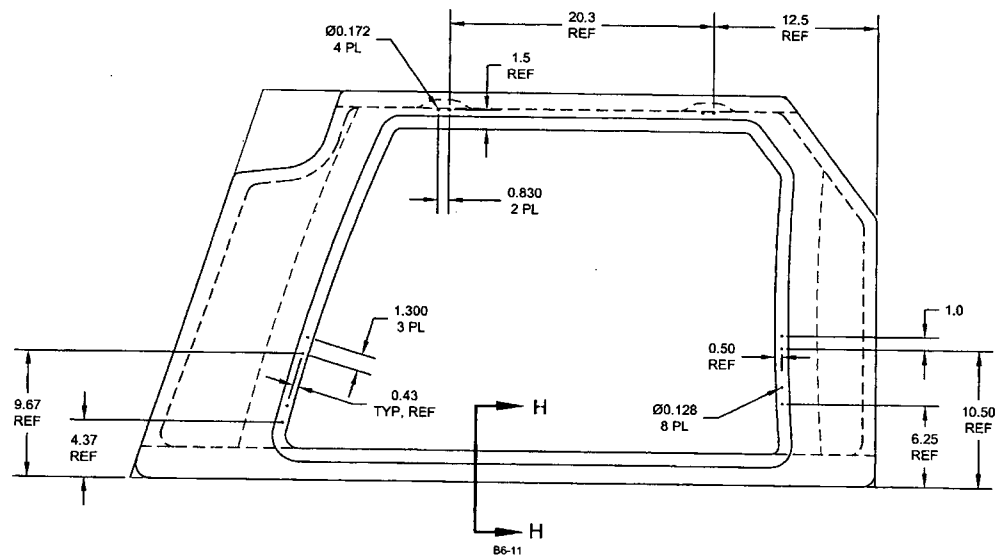
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries









**D3188-3 SPACEPOD BODY**  
MAKE FROM D3188-3M

**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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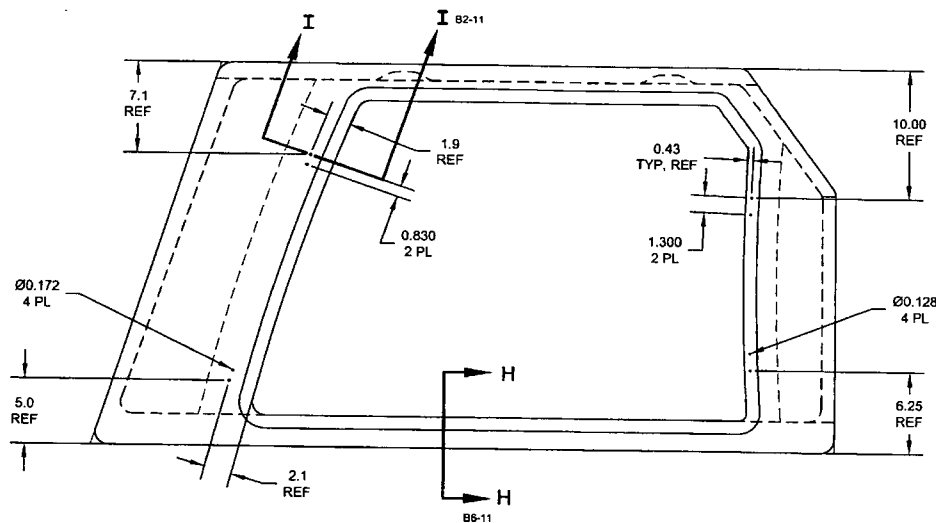
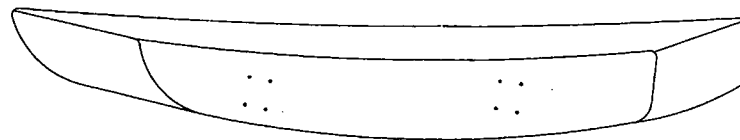
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries







**D3188-5 SPACEPOD BODY**  
MAKE FROM D3188-1M

**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

**RELEASED**  
2009-10-20

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MFG. APPR.		D3188	SHEET 5 OF 11
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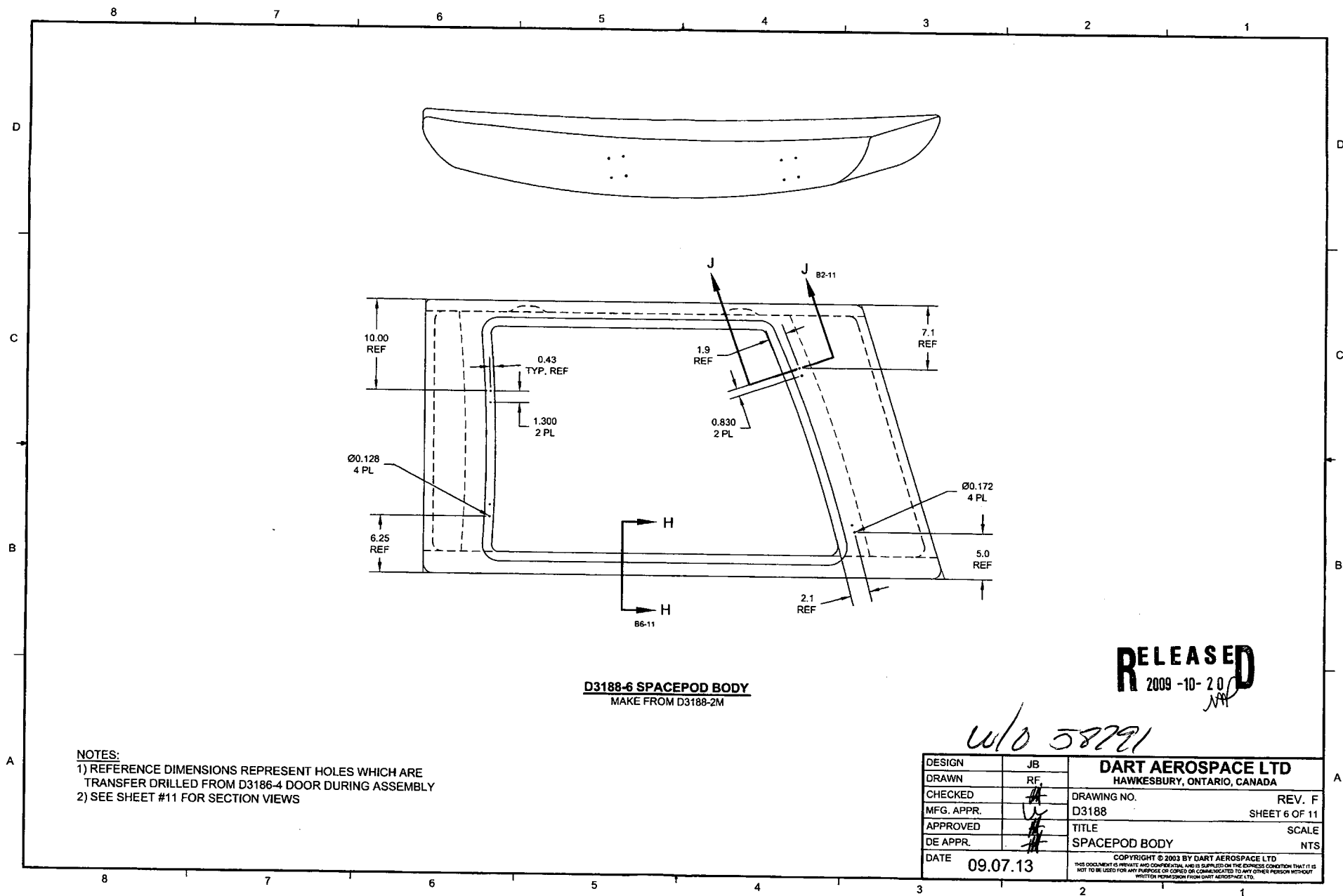
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



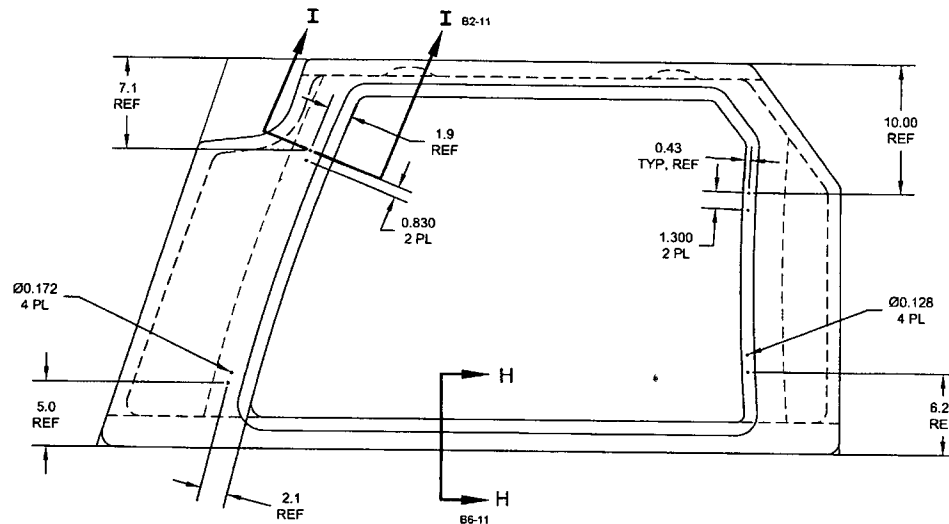
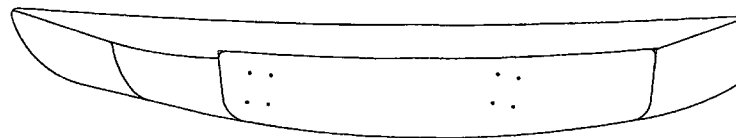
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			





NOTE: Date & initial all entries



**D3188-7 SPACEPOD BODY**  
MAKE FROM D3188-3M

NOTE:  
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE  
TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY  
2) SEE SHEET #11 FOR SECTION VIEWS

**RELEASED**  
2009-10-20

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CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3188	SHEET 7 OF 11
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

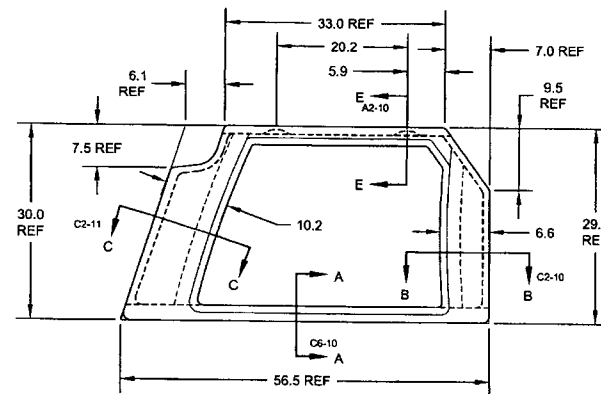
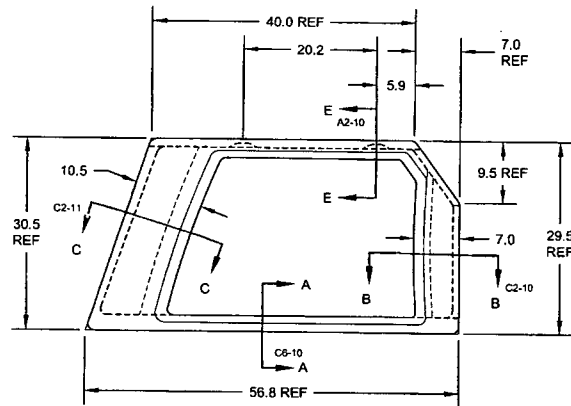
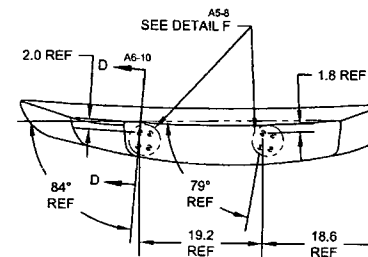
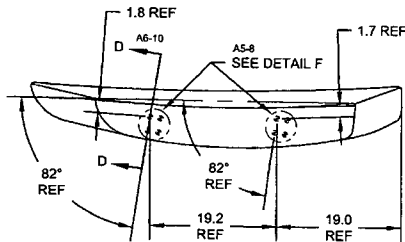
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

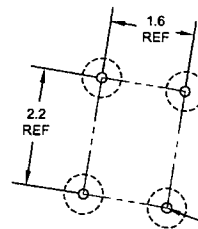
**NOTE:** Date & initial all entries





**D3188-1M SPACEPOD BODY**

**D3188-3M SPACEPOD BODY**



**DETAIL F**

INSTALL  
D2213 SPACER  
8 PL  
SEE SECTION D-D  
A5-10

**D3188-1M/-3M NOTES:**  
1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.  
2) SEE SHEET #10 FOR SECTION VIEWS.

**RELEASED**  
2009-10-23

DESIGN	JB	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3188	REV. F
MFG. APPR.			SHEET 8 OF 11
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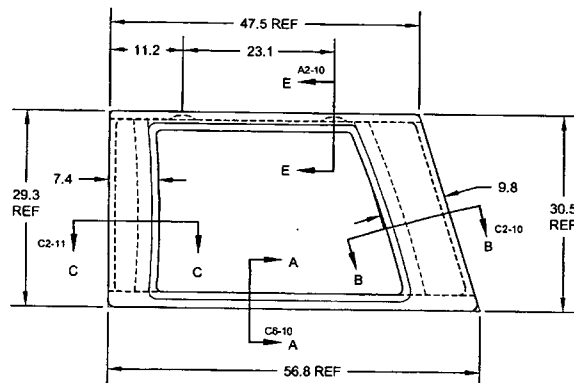
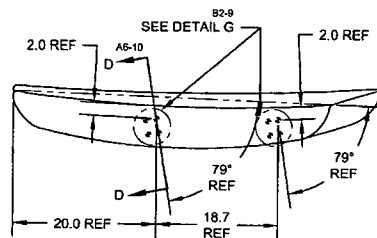
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

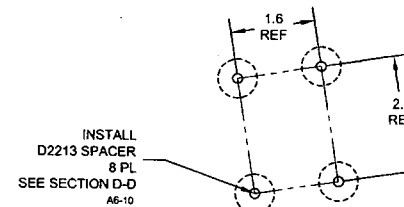
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3188-2M SPACEPOD BODY**



**DETAIL G** D0-9

**RELEASED**  
2009-10-20

**D3188-2M NOTES:**

- 1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 9 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

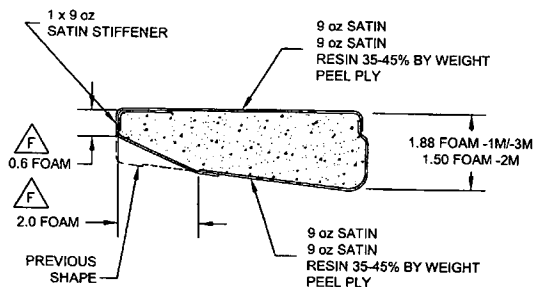
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

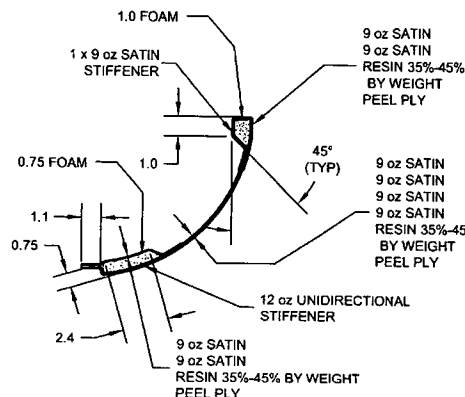
**NOTE:** Date & initial all entries

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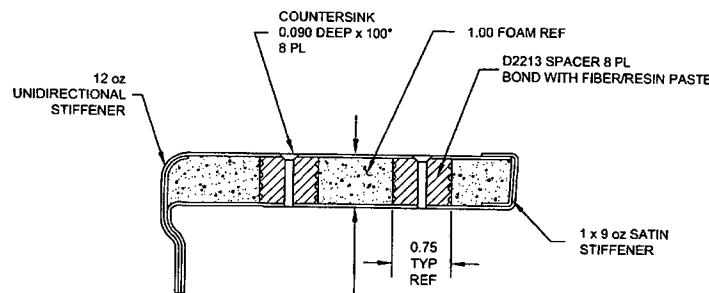
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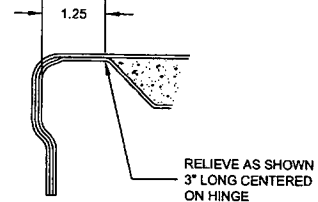
**SECTION A-A**  
TYPICAL FLOOR SECTION  
B7-8  
B3-8  
B6-8



**SECTION B-B**  
SECTION C-C OPPOSITE  
B6-8  
B8-8  
B4-8  
B2-8  
B7-9  
B5-9



**SECTION D-D**  
TYPICAL ROOF SECTION IS SIMILAR  
BUT WITHOUT INSERTS  
D3-8  
D7-8  
D6-8



**SECTION E-E**  
2 PLACES PER POD  
C2-8  
C7-8  
B6-8

**RELEASED**  
2009-10-27  
JAP

DESIGN	JB	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<del>RF</del>	DRAWING NO. D3188	REV. F
MFG. APPR.	<del>RF</del>		SHEET 10 OF 11
APPROVED	<del>RF</del>	TITLE	SCALE
DE APPR.	<del>RF</del>	SPACEPOD BODY	NTS
DATE	09.07.13	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. NO IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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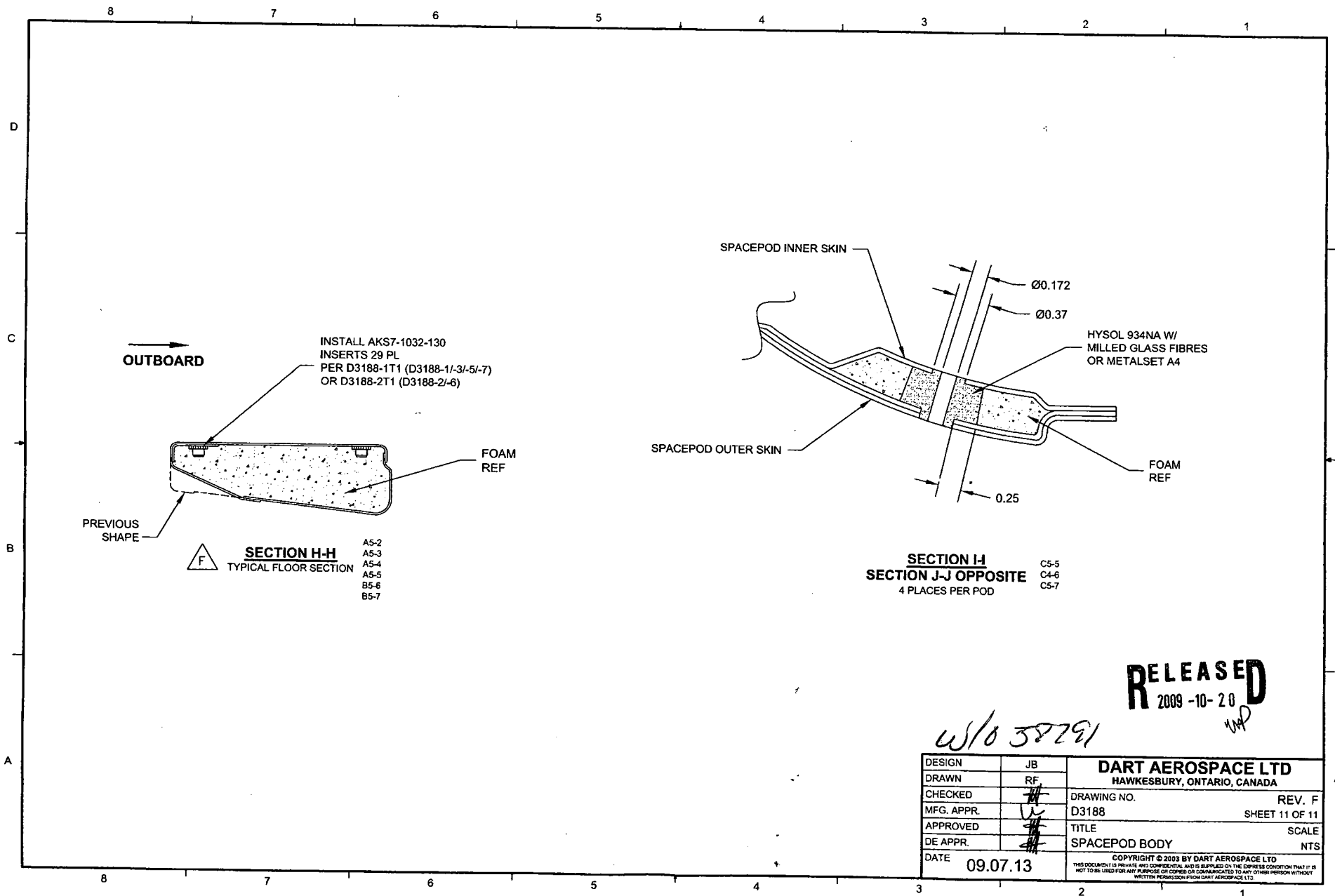
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries